

WHAT IS CLAIMED IS:

1. A vertical machining center comprising:  
a tool slide which can be moved in a controlled manner;  
a workpiece feed on one side of a machining area; and  
a moveable vertical machining center component that can be controlled in  
at least one axis to change workpieces between the workpiece feed and the  
machining area;  
said workpiece feed being adapted to hold available and accept workpiece  
holders with workpieces and being mounted so as to be in alignment with a CNC  
rotary table on that side of the vertical machining center, on which the  
respective workpiece holder is held by the CNC rotary table.
2. A vertical machining center, as claimed in claim 1, wherein the  
workpiece feed comprises a magazine, the movement of which can be timed and  
which has a plurality of receivers for workpiece holders.
3. A vertical machining center, as claimed in claim 2, wherein the  
workpiece feed comprises a magazine wheel which carries the receivers and can  
be swiveled about a central axis.
4. A vertical machining center, as claimed in any one of claims 1-3,  
wherein the CNC rotary table can be moved on guides in the direction of the  
workpiece feed to change the workpiece holders.
5. A vertical machining center, as claimed in claim 4, further  
comprising a counter-vice to hold the tool carrier on the side, facing the

workpiece feed and facing away from the CNC rotary table, said counter-vise being mounted so as to be traversable with the workpiece holder out of the collision area.

6. A vertical machining center, as claimed in claim 4, wherein the counter-vise has a holder for clamping the workpiece carrier, which is designed for swiveling the respective workpiece carrier 180° between a position facing the CNC rotary table and a position facing the workpiece feed, and the counter-vise is traversable on guides in the direction of the workpiece feed.

7. A vertical machining center, as claimed in one of claims 1-3, wherein to move the CNC rotary table or the counter-vise, the tool slide and the CNC rotary table or the counter-vise have docking means.

8. A vertical machining center, as claimed in one of claims 1-3, wherein the tool slide has a gripper to change the workpiece holders.